



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D3204-041
Job Sheet 179749-A



Part No: D3204-041

Job Qty: 1 ea

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/18/18

Created By: Eric Larocque

Type: Stock

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-1		EL
100	Large Fab	1 pcs	7/18/18	7/18/18	0.00	1.30	Large Fab 8		EL
110	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC9		CPC
120	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC5		CPC
130	HandFinish	1 pcs	7/18/18	7/18/18	0.00	0.09	HandFinish1		SA 18-07-18
140	Powdercoat	1 pcs	7/18/18	7/18/18	0.00	0.07	Powdercoat3		17-18-7-19
150	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC3		
160	Small Fab	1 pcs	7/18/18	7/18/18	0.00	0.07	Small Fab-3		DAS
170	QC	1 pcs	7/18/18	7/18/18	0.00	0.00	QC5		38
180	Packaging	1 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1		9-88
190	QC21-SA	1 Ea	7/18/18	7/18/18	0.00	0.00	QC21		

Part Op 100 - 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts D3204-1,3,5,13 on jig. 5 2018
Descriptions: number DT10295 for tacking parts together. 3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods... 4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal. 5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps... 7:30

140 - ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: 300° FINISH TIME: 9:00

180 - LOCATION : GA

M B630

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	1 Ea (1 ea)	90-Start up Operation	
D3204-11	Plate	1 Ea (1 ea)	90-Start up Operation	
D3204-13	Gusset	2 Ea (2 ea)	90-Start up Operation	
D3204-3	Arm	1 Ea (1 ea)	90-Start up Operation	
			rt up Operation	
			rt up Operation	
			nall Fab	



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Container No: S092876



Part: D3204-041

Job No: 179749-A

Serial No/Batch: S092875

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/18/18

Plex 7/17/18 3:19 PM dart.larocque.eric